



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200



*April 4*  
**D4686-1**  
**Job Sheet 174482**

Part No: D4686-1

Job Qty: *25* ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/16/18

Job Tracking No:

Due Date: 4/4/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Ship Via:

*DAS 10 9-89*  
*Aug D4686 REV B*

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |                 | Sign-off           |
|-------|--------------------|--------|------------|----------|-----------|---------|-----------------------|-----------------|--------------------|
|       |                    |        |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time       |                    |
| 90    | Start up Operation | 20 Ea  | 4/3/18     | 4/3/18   | 0.00      | 0.00    | Start Up Machining-3  | <i>77 ml</i>    | <i>JB 18-03-26</i> |
| 100   | Hardinge           | 20 pcs | 4/3/18     | 4/3/18   | 0.01      | 0.59    | Hardinge              |                 | <i>JB 18-03-26</i> |
| 120   | QC                 | 20 pcs | 4/3/18     | 4/3/18   | 0.00      | 0.00    | QC8                   |                 | <i>JB 18/03/27</i> |
| 122   | Outsource          | 20 pcs | 4/3/18     | 4/3/18   |           |         | MEI001-VC             | <i>ROB 9483</i> | <i>CT 18/04/02</i> |
| 124   | Packaging          | 20 pcs | 4/3/18     | 4/3/18   | 0.00      | 0.00    | Packaging2            |                 | <i>DAS</i>         |
| 126   | QC                 | 20 pcs | 4/3/18     | 4/3/18   | 0.00      | 0.00    | QC6                   |                 | <i>11</i>          |
| 130   | HandFinish         | 20 pcs | 4/4/18     | 4/4/18   | 0.00      | 0.50    | HandFinish1           |                 | <i>9-89</i>        |
| 140   | QC                 | 20 pcs | 4/4/18     | 4/4/18   | 0.00      | 0.00    | QC7-4                 |                 | <i>11</i>          |
| 150   | Packaging          | 20 pcs | 4/4/18     | 4/4/18   | 0.00      | 0.00    | Packaging3-2          |                 | <i>11</i>          |
| 160   | QC21-SA            | 20 Ea  | 4/4/18     | 4/4/18   | 0.00      | 0.00    | QC21                  |                 | <i>21</i>          |

Part Op 100 - Machine as per Folio FB164

Descriptions: 122 - HEAT TREAT TO T4/T42 CONDITION MIN. UTS=30 KSI (60 HREW MIN) NOTE: DETAIL C OF C REQUIRED

PART ARE MADE FROM 6061-T6 MATERIAL

124 - ENSURE C OF C IS ATTACH

150 - \*\*\*STOCK IN SKIDTUBE CELL\*\*

### Job BOM

| Part / Item        | Component Name                 | Quantity           | Operation             | Container |
|--------------------|--------------------------------|--------------------|-----------------------|-----------|
| M6061T6T0.750W.058 | 6061-T6 Round Tube .750 X.058W | 8.8000 ft (.44 ea) | 90-Start up Operation |           |

### Job Allocations

| Operation             | Component Part     | Required | Inventory | Allocated |
|-----------------------|--------------------|----------|-----------|-----------|
| 90-Start up Operation | M6061T6T0.750W.058 | 9        | 89        | 0         |

### Part Specifications

| Spec No | Description | Target/Tolerance    | Limits         | Type | Special Comments    |
|---------|-------------|---------------------|----------------|------|---------------------|
| 1       | Spacer      | 0.750Inches ± 0.010 | 0.760<br>0.740 |      | Reference, Diameter |
| 2       | Spacer      | 0.058Inches ± 0.010 | 0.068<br>0.048 |      | Reference           |
| 3       | Spacer      | 5.200Inches ± 0.063 | 5.263<br>5.138 |      |                     |

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____<br><br>Date : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Cross tube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/>             | Cross tube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/>   | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/>     |                                             |                            |                                        |                                   |                                 |                             |                                       |                                   |                                                 |                                           |                                   |                                          |                                |                                         |                                             |                                           |                                   |                                  |                                           |                                  |                                     |                                     |                              |                                              |                                             |                                       |                                     |                                              |                                        |                                                |                                           |                                                |                                      |                                           |                                        |                                   |               |  |
| Skid-tube <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     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Eng. Coord. <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | Quality <input type="checkbox"/>               |                                     |                                    |                                      |                                    |                                      |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                       |                                             |                            |                                        |                                   |                                 |                             |                                       |                                   |                                                 |                                           |                                   |                                          |                                |                                         |                                             |                                           |                                   |                                  |                                           |                                  |                                     |                                     |                              |                                              |                                             |                                       |                                     |                                              |                                        |                                                |                                           |                                                |                                      |                                           |                                        |                                   |               |  |
| Thermoforming <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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| Large Fab <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     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                 |                                                |                                           |                                                |                                      |                                           |                                        |                                   |               |  |
| <b>Description</b><br><br><div style="text-align: right; font-size: small;">           Dart Aerospace Ltd.<br/>           1270 Aberdeen Street<br/>           Newbury, ON K6A 1K7<br/>           CANADA<br/>           TEL.: 1 613 632-5200<br/>           Email: sales@dartaero.com<br/>           www.dartaero.com         </div> <div style="text-align: center;"> <br/> <b>Container No: S054939</b><br/> <br/> <b>Part: D4686-1</b><br/> <b>Job No: 17482</b><br/> <b>Serial No/Batch: S054939</b><br/> <b>Revision: B</b><br/> <b>Inspector:</b> </div> <div style="text-align: right; margin-top: 20px;">           Date: 03/26/18         </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                   | Effective : _____<br><br>MRB (QSI042) Approval<br><br>Completed By<br><br>Lead hand / Supervisor<br>Approval Verification<br><br>QC / QA Coordinator<br>Approval                                                                                                                                                                                                                                                                                                                                                                                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| <table style="width:100%;"> <tr> <td colspan="2"><b>Root Cause</b></td> <td></td> <td></td> </tr> <tr> <td>Environment <input type="checkbox"/></td> <td>No <input type="checkbox"/></td> <td></td> <td>Loss/Surge <input type="checkbox"/></td> </tr> <tr> <td>Design <input type="checkbox"/></td> <td>Operator <input type="checkbox"/></td> <td></td> <td>/Program <input type="checkbox"/></td> </tr> <tr> <td>Doc/Data <input type="checkbox"/></td> <td>Offset/Setup <input type="checkbox"/></td> <td>Centre Not Correct <input type="checkbox"/></td> <td>n <input type="checkbox"/></td> </tr> <tr> <td>Equip/Tooling <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td>Cracks <input type="checkbox"/></td> <td>id <input type="checkbox"/></td> </tr> <tr> <td>Handling/Pre <input type="checkbox"/></td> <td>Training <input type="checkbox"/></td> <td>Crimp/Kink/Ripple/Wave <input type="checkbox"/></td> <td>ong Stock Pulled <input type="checkbox"/></td> </tr> <tr> <td>Material <input type="checkbox"/></td> <td>Use for Testing <input type="checkbox"/></td> <td>Cuffs <input type="checkbox"/></td> <td>nt of Sequence <input type="checkbox"/></td> </tr> <tr> <td>Internal Transport <input type="checkbox"/></td> <td>Poor Information <input type="checkbox"/></td> <td>Crushing <input type="checkbox"/></td> <td>Off-set <input type="checkbox"/></td> </tr> <tr> <td>Tribal Knowledge <input type="checkbox"/></td> <td>Rushing <input type="checkbox"/></td> <td>Heat Treat <input type="checkbox"/></td> <td>Mislabeled <input type="checkbox"/></td> </tr> <tr> <td>LOA <input type="checkbox"/></td> <td>Product Improvement <input type="checkbox"/></td> <td>Wave/Twist in Tube <input type="checkbox"/></td> <td>Fit/Function <input type="checkbox"/></td> </tr> <tr> <td>Substation <input type="checkbox"/></td> <td>Process Improvement <input type="checkbox"/></td> <td>Marks/Chatter <input type="checkbox"/></td> <td>Misaligned/off center <input type="checkbox"/></td> </tr> <tr> <td>Past Expiry Date <input type="checkbox"/></td> <td>Manufacturing Process <input type="checkbox"/></td> <td>Drill Holes <input type="checkbox"/></td> <td>Positioned Wrong <input type="checkbox"/></td> </tr> <tr> <td>Misidentified <input type="checkbox"/></td> <td>Past Due <input type="checkbox"/></td> <td colspan="2">OTHER : _____</td> </tr> </table> |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                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<input type="checkbox"/> | Cracks <input type="checkbox"/> | id <input type="checkbox"/> | Handling/Pre <input type="checkbox"/> | Training <input type="checkbox"/> | Crimp/Kink/Ripple/Wave <input type="checkbox"/> | ong Stock Pulled <input type="checkbox"/> | Material <input type="checkbox"/> | Use for Testing <input type="checkbox"/> | Cuffs <input type="checkbox"/> | nt of Sequence <input type="checkbox"/> | Internal Transport <input type="checkbox"/> | Poor Information <input type="checkbox"/> | Crushing <input type="checkbox"/> | Off-set <input type="checkbox"/> | Tribal Knowledge <input type="checkbox"/> | Rushing <input type="checkbox"/> | Heat Treat <input type="checkbox"/> | Mislabeled <input type="checkbox"/> | LOA <input type="checkbox"/> | Product Improvement <input type="checkbox"/> | Wave/Twist in Tube <input type="checkbox"/> | Fit/Function <input type="checkbox"/> | Substation <input type="checkbox"/> | Process Improvement <input type="checkbox"/> | Marks/Chatter <input type="checkbox"/> | Misaligned/off center <input type="checkbox"/> | Past Expiry Date <input type="checkbox"/> | Manufacturing Process <input type="checkbox"/> | Drill Holes <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/> | Misidentified <input type="checkbox"/> | Past Due <input type="checkbox"/> | OTHER : _____ |  |
| <b>Root Cause</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      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| Environment <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   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| Equip/Tooling <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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| Handling/Pre <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  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| Material <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      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| Internal Transport <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | Poor Information <input type="checkbox"/>                                                                                         | Crushing <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Off-set <input type="checkbox"/>               |                                     |                                    |                                      |                                    |                                      |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                       |                                             |                            |                                        |                                   |                                 |                             |                                       |                                   |                                                 |                                           |                                   |                                          |                                |                                         |                                             |                                           |                                   |                                  |                                           |                                  |                                     |                                     |                              |                                              |                                             |                                       |                                     |                                              |                                        |                                                |                                           |                                                |                                      |                                           |                                        |                                   |               |  |
| Tribal Knowledge <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | Rushing <input type="checkbox"/>                                                                                                  | Heat Treat <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | Mislabeled <input type="checkbox"/>            |                                     |                                    |                                      |                                    |                                      |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                       |                                             |                            |                                        |                                   |                                 |                             |                                       |                                   |                                                 |                                           |                                   |                                          |                                |                                         |                                             |                                           |                                   |                                  |                                           |                                  |                                     |                                     |                              |                                              |                                             |                                       |                                     |                                              |                                        |                                                |                                           |                                                |                                      |                                           |                                        |                                   |               |  |
| LOA <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | Product Improvement <input type="checkbox"/>                                                                                      | Wave/Twist in Tube <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | Fit/Function <input type="checkbox"/>          |                                     |                                    |                                      |                                    |                                      |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                       |                                             |                            |                                        |                                   |                                 |                             |                                       |                                   |                                                 |                                           |                                   |                                          |                                |                                         |                                             |                                           |                                   |                                  |                                           |                                  |                                     |                                     |                              |                                              |                                             |                                       |                                     |                                              |                                        |                                                |                                           |                                                |                                      |                                           |                                        |                                   |               |  |
| Substation <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | Process Improvement <input type="checkbox"/>                                                                                      | Marks/Chatter <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | Misaligned/off center <input type="checkbox"/> |                                     |                                    |                                      |                                    |                                      |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                       |                                             |                            |                                        |                                   |                                 |                             |                                       |                                   |                                                 |                                           |                                   |                                          |                                |                                         |                                             |                                           |                                   |                                  |                                           |                                  |                                     |                                     |                              |                                              |                                             |                                       |                                     |                                              |                                        |                                                |                                           |                                                |                                      |                                           |                                        |                                   |               |  |
| Past Expiry Date <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | Manufacturing Process <input type="checkbox"/>                                                                                    | Drill Holes <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | Positioned Wrong <input type="checkbox"/>      |                                     |                                    |                                      |                                    |                                      |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                       |                                             |                            |                                        |                                   |                                 |                             |                                       |                                   |                                                 |                                           |                                   |                                          |                                |                                         |                                             |                                           |                                   |                                  |                                           |                                  |                                     |                                     |                              |                                              |                                             |                                       |                                     |                                              |                                        |                                                |                                           |                                                |                                      |                                           |                                        |                                   |               |  |
| Misidentified <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Past Due <input type="checkbox"/>                                                                                                 | OTHER : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                |                                     |                                    |                                      |                                    |                                      |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                       |                                             |                            |                                        |                                   |                                 |                             |                                       |                                   |                                                 |                                           |                                   |                                          |                                |                                         |                                             |                                           |                                   |                                  |                                           |                                  |                                     |                                     |                              |                                              |                                             |                                       |                                     |                                              |                                        |                                                |                                           |                                                |                                      |                                           |                                        |                                   |               |  |





Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# **PURCHASE ORDER** **PO039483**

**Supplier:** MEI001-VC  
Metcor Inc.  
560 Boul. Arthur Sauve  
Saint-Eustache  
QC  
J7R 5A8 Canada  
Phone: 450 473 1884  
Fax: 450 491 5498

**PO No:** PO039483  
**PO Date:** 4/2/18  
**Due Date:** 4/12/18  
**Purchase Order**  
**Revision:**  
**Revision Date:**  
**Ship-To Contact:** Tsimiklis, Chrisoula

**Ship To:** 1270 Aberdeen Street  
Hawkesbury  
ON  
K6A 1K7 Canada  
Phone: 613-632-5200

**Via:** Ground  
**Pymt Terms:** Net 30  
**Freight Terms:**  
**Special Comments:**

## **Items**

| Line Item | Job    | Part     | Description                                                                                                                                                                                                         | Status | Due Date | Order Quantity | Received Quantity | Balance               | Unit Price (CAD) | Extended Price |
|-----------|--------|----------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|----------|----------------|-------------------|-----------------------|------------------|----------------|
| 1         | 174484 | D5304-1  | Crossbolt Spacer<br>1-Issue P/O to<br>Metcore ;<br>P/O<br>HEAT TREAT TO<br>T4/T42 CONDITION<br>MIN. UTS=30 KSI<br>(60 HREW MIN)<br>NOTE: DETAIL C OF<br>C REQUIRED<br><br>PART ARE MADE<br>FROM 6061-T6<br>MATERIAL | Firmed | 4/12/18  | 22 pcs<br>✓    | 0 pcs<br>22x      | 22 pcs<br>AT 18/04/13 | \$1.207052/pcs   | \$26.56        |
| 2         | 174482 | D4686-1  | Spacer<br>HEAT TREAT TO<br>T4/T42 CONDITION<br>MIN. UTS=30 KSI<br>(60 HREW MIN)<br>NOTE: DETAIL C OF<br>C REQUIRED<br><br>PART ARE MADE<br>FROM 6061-T6<br>MATERIAL                                                 | Firmed | 4/12/18  | 25 pcs<br>✓    | 0 pcs<br>25x      | 25 pcs<br>AT 18/04/13 | \$1.207052/pcs   | \$30.18        |
| 3         | 171982 | 646.3314 | Blade<br>HEAT TREAT AS<br>PER DWG 646.3300<br>FINISH: HEAT<br>TREAT TO 58-62 RC<br>ROCKWELL<br>HARDNESS<br><br>PART ARE MADE<br>FROM AISI A2<br>TOOL STEEL                                                          | Firmed | 4/12/18  | 16 pcs<br>✓    | 0 pcs<br>16x      | 16 pcs<br>AT 18/04/13 | \$19.50/pcs      | \$312.00       |

DAS  
11  
9-89

# METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

## Certificat de Conformité Certificate of Compliance

| BON DE TRAVAIL<br>order | CHARGEMENT<br>load |
|-------------------------|--------------------|
| 326642                  | 1                  |

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

1

| COMMANDE DU CLIENT<br>customer po | CLASSIFICATION PIECE<br>part classification | MATÉRIEL<br>material | MAÎTRE D'OEUVRE<br>prime contractor | PROGRAM |
|-----------------------------------|---------------------------------------------|----------------------|-------------------------------------|---------|
| 039483                            | N/A                                         | AL-6061              |                                     |         |

### SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T42

| EXIGENCE / requirement                   | SPÉCIFICATIONS / specified | TESTS EXÉCUTÉS / performed | RÉSULTATS DE TESTS / results |
|------------------------------------------|----------------------------|----------------------------|------------------------------|
| CONDUCTIVITY                             | 35 - 43 %IACS              | 20                         | 39 - 41 %IACS                |
| HARDNESS                                 | 60 HREW MIN                | 20                         | 61 - 62,5 HREW               |
| DURETE MESUREE EN HR15TW 63-64<br>HR15TW |                            |                            |                              |

| QUANTITÉ<br>quantity | POIDS<br>weight | DESCRIPTION DES PIÈCES<br>parts description                                                                        |
|----------------------|-----------------|--------------------------------------------------------------------------------------------------------------------|
| 553                  | 20              | D5304-1<br>(22) D5304-1 JOB. 17448<br>(25) D4686-1 JOB 174482<br>(506) D4202-1 JOB 173722<br><br>1 BOITE DE CARTON |

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

DATE: 2018-04-12

Pierre Piché  
Chief Inspector



APPROUVÉ



# METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

## Certificat de Conformité Détail

Detailed Certificate of Compliance

| BON DE TRAVAIL<br>order | CHARGEMENT<br>load |
|-------------------------|--------------------|
| 326642                  | 1                  |

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

| COMMANDE DU CLIENT<br>customer po                                                                                                        | CLASSIFICATION PIECE<br>part classification | MATÉRIEL<br>material                                                                                               | MAÎTRE D'OEUVRE<br>prime contractor                        | PROGRAM |
|------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------|--------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------|---------|
| 039483                                                                                                                                   | N/A                                         | AL-6061                                                                                                            |                                                            |         |
| <div>SPÉCIFICATIONS DU PROCÉDÉ</div> <div>processing specifications</div> <div>SOL ANNEAL</div> <div>SINGLE AGING TO CONDITION T42</div> |                                             |                                                                                                                    |                                                            |         |
| EXIGENCE / requirement                                                                                                                   | SPÉCIFICATIONS / specified                  | TESTS EXÉCUTÉS / performed                                                                                         | RÉSULTATS DE TESTS / results                               |         |
| CONDUCT                                                                                                                                  | 35 - 43 %IACS                               | 20<br>(60 kHz)                                                                                                     | 39 - 41 %IACS                                              |         |
| HARDNESS                                                                                                                                 | 60 HREW MIN                                 | 20                                                                                                                 | 61 - 62.5 HREW<br>DURETE MESUREE EN HR15TW 63-64<br>HR15TW |         |
| QUANTITÉ<br>quantity                                                                                                                     | POIDS<br>weight                             | DESCRIPTION DES PIÈCES<br>parts description                                                                        |                                                            |         |
| 553                                                                                                                                      | 20                                          | D5304-1<br>(22) D5304-1 JOB. 17448<br>(25) D4686-1 JOB 174482<br>(506) D4202-1 JOB 173722<br><br>1 BOITE DE CARTON |                                                            |         |

### COMMENTAIRES / comments

SOL. ANNEAL 985F, 40 MIN  
AGE HARDEN AMBIANT, 96 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Ce document et les documents qui lui sont joints peuvent contenir des informations confidentielles, être soumis aux

# METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

## Certificat de Conformité Détail

Detailed Certificate of Compliance

| BON DE TRAVAIL<br>order | CHARGEMENT<br>load |
|-------------------------|--------------------|
| 326642                  | 1                  |

CLIENT / customer 215

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1270 ABERDEEN

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LIVRÉ À / shipped to:

1

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

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APPROUVÉ par / Approved by:

Isabel Otero

QA Technician



DATE: 2018-04-13